

Work Order ID 117509

Thursday, April 24, 2014 2:08:00 PM

117509

Page 1

Item ID: D500-560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Mirror Installation
 Start Date: 4/24/2014 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/1/2014 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 14-4-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00			DAS 31 9-89				DAS 28 9-89
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D500-560-041 CHG006								
110	Small Fab	0.00							
110	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Before assembly repass tap on stud. Assemble as per drawing D500-560 PAGE 8- BLUE FILE								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC								
Quality Control	Memo	0.00							

14/4/25

2x 14-4-24

2 FF 14-04-24

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Thursday, April 24, 2014 2:08:00 PM

Item ID: D500-560-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Mirror Installation

Start Date: 4/24/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/1/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00				2x		14-4-25	
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.00				2x		14-04-28	
Quality Control									
150	Packaging	0.00							
150									
Packaging	Memo	0.00				2			
Packaging	Identify and pack for shipping as per PPP D500-560-041								
	Location: <u>011A</u>								
	PPP Rev: _____								

DAS
26
9-89

DAS
31
9-89

DAS
06
9-89

APR 28 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Material									
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

Item ID: D500-560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Mirror Installation

Start Date: 4/24/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/1/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14/4/29 *[Signature]*
[Signature] 14.04.28

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Doc/Data									
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

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Work Order ID: 117509

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Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation

Start Date: 4/24/2014

Required Date: 5/1/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G
10.04.22 chg route seq DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-4A *AN3-4A* Bolt		Purchased	No			140	Each	412.0000	4	8			DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST350				364					
				m128429				100					
				m128739				264					
				ST511				48					
				m127044				48					
AN526C1032R10 *AN526C1032R10* Screw		Purchased	No			110	Each	155.0000	4	8			14-4-24
				<u>Location</u>				<u>Loc Qty</u>					
				FP001				22					
				108062				22					
				ST505				133					
				m128712				133					
D1048 *D1048* Clamp		Manufactured	No			110	Each	34.0000	2	4			FF 14-04-24
				<u>Location</u>				<u>Loc Qty</u>					
				GA				34					
				115372				34					

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 117509

117509

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation

Start Date: 4/24/2014

Required Date: 5/1/2014

Start Qty: 2.00

Required Qty: 2.00

D1049

Manufactured No

110

Each

18.0000

2

4

D1049

Saddle

**

FF 14-04-24

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

18

108735

2

115511

16

D2010-101

Manufactured No

110

Each

10.0000

1

2

D2010-101

Mirror Bracket 369/500

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST220

10

105122

10

D2010-103

Manufactured No

110

Each

7.0000

1

2

D2010-103

Mirror Arm 369/500

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST220

7

104979

7

D2011-101

Manufactured No

110

Each

13.0000

1

2

D2011-101

Mirror 6"

**

14-4-24

Location

Loc Qty

Loc Code

FG

2

106348

2

ST179

11

113569

11

DAS
26
9-89

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Shop Packet Print

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DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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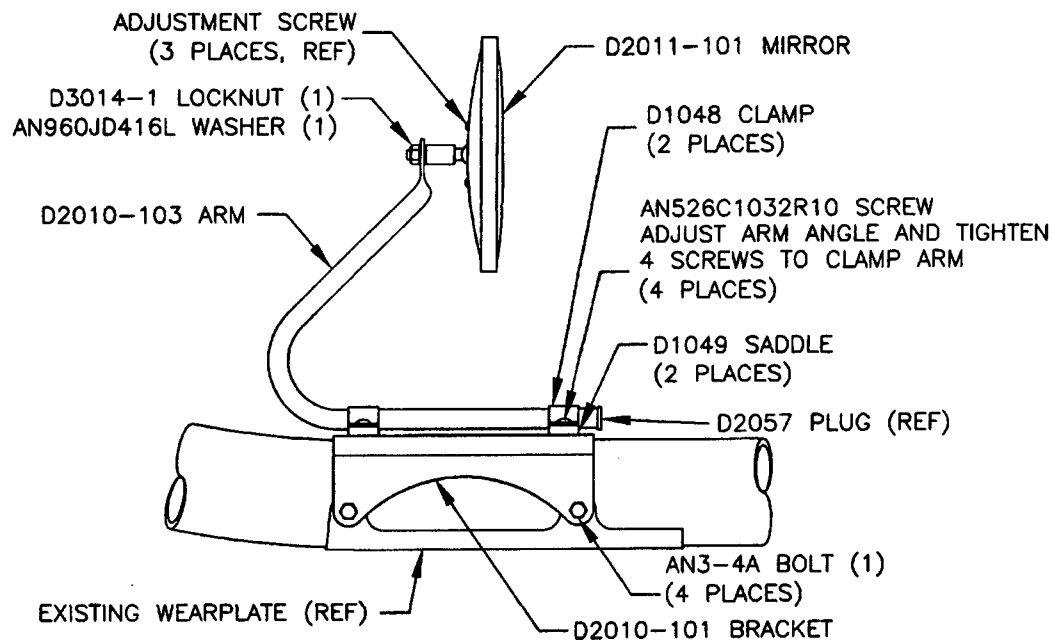


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041	1.0 lb	-45 in	-45 lb-kG	24 in	24 in-lb
Cargo Mirror Assembly	0.45 kg	-1.14 m	-0.51 m-kG	0.61 m	0.27 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

*PARTS ARE INCLUDED WITH D2011-101 MIRROR

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FAULT CATEGORY

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Page 1

Item ID: D500-560-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cargo Mirror Installation
 Start Date: 4/24/2014 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/1/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ME Date: 4-4-24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D500-560-041 CHG006								
110	Small Fab	0.00							
110	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Before assembly repass tap on stud. Assemble as per drawing D500-560 PAGE 8- BLUE FILE								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC	0.00							
Quality Control	Memo								

MLJ 14-04-25
 2x 14-4-24
 DAS 28 9-00

2 FF 14-04-24

DAS
 27
 9-00

14/4/23